

Date: Monday, 6/12/2006 2:25:07 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 27473					
Estimate Number	: 10618					
P.O. Number	: N/A			Part Number	: D265637	
This Issue	: 6/12/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2656 REV D	
First Issue	: N/A		Type	: PURCHASED PARTS		
Previous Run	: 26366			Project Number	: N/A	
Written By	<i>(See comment below)</i>			Drawing Revision	: D	
Checked & Approved By	<i>(initials)</i> 06-06-12 K			Material	: N/A	
Comment	: Est Rev D 02.10.25 Re-format KJ			Due Date	: 6/30/2006	
	Est Rev: E 06-06-12 Now on Waterjet JLM			Qty:	20	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S20GA	1010/1025/A21/6aA SHEET
		<i>1010/1025 .040" SHEET (M1010S20GA)</i>
		<i>Batch: M1010473</i>
2.0	WATER JET	FLOW WATER JET
		<i>Comment: FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: D Prog Rev: D</i>
		<i>5/10 06-06-11 06-06-13</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</i>
4.0	QC8	SECOND CHECK
		<i>Comment: SECOND CHECK</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		<i>Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.</i>
		<i>REF- M.F. 06-06-20</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: Date: 06/07/04

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 2:25:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 27473

Part Number: D265637

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326.

2- Identify as D2656-37

SB 06/06/27

20

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 07 08

20

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.M 06-07-08

20

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP21

FC 06 07 08 20

11.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/06 20

Job Completion



U 06-07-08

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

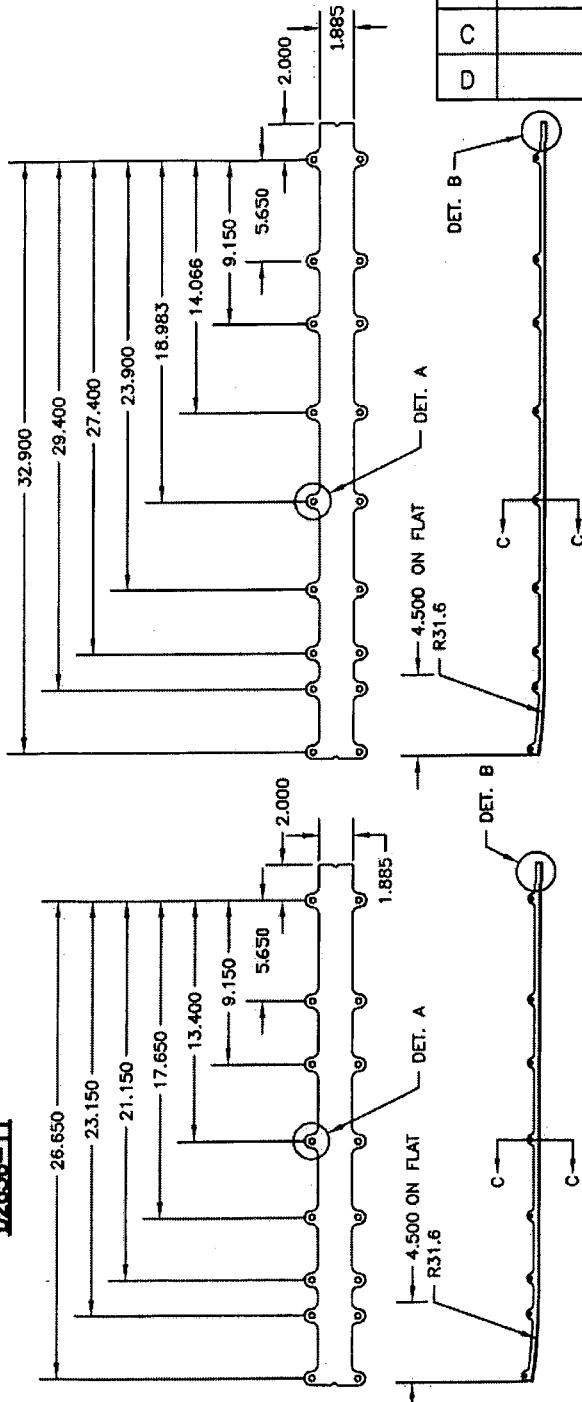
QA: N/C Closed: _____

Date: _____

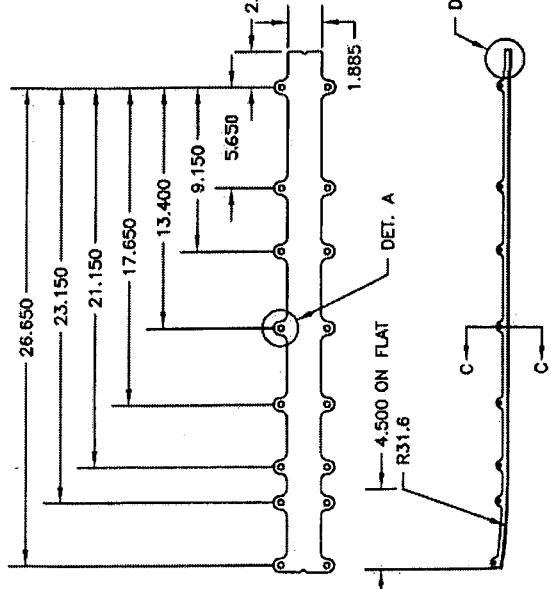
DART

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	DS	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2656	SHEET 1 OF 4
DATE		TITLE	SCALE
05.08.17		WEARSHOE	1:10
A	97:03:25	NEW ISSUE	
B	97:06:02	CHANGED TABS	
C	97:06:26	R31.6 WAS R19.5	
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT	

D2656-13



D2656-11



D2656-15

NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6)
TOLERANCES ARE PER DART QSI 018
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WITHOUT NOTICE
WORK ORDER
NO. 27473

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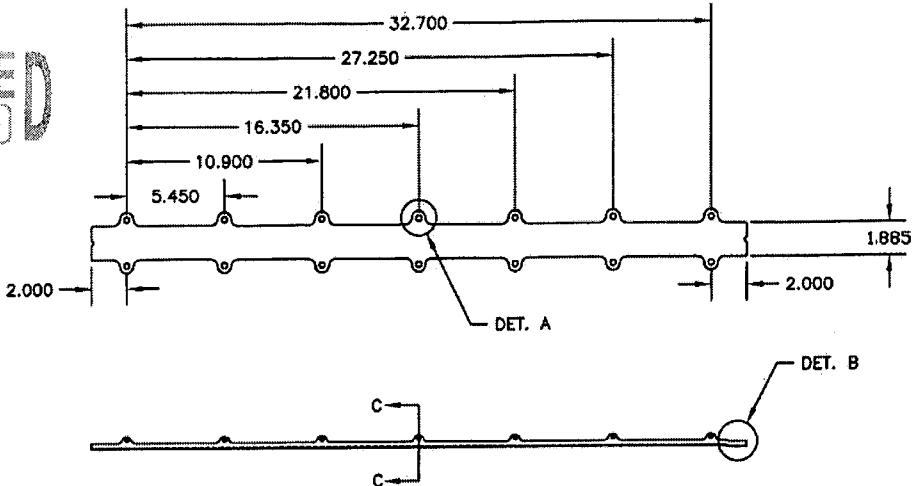
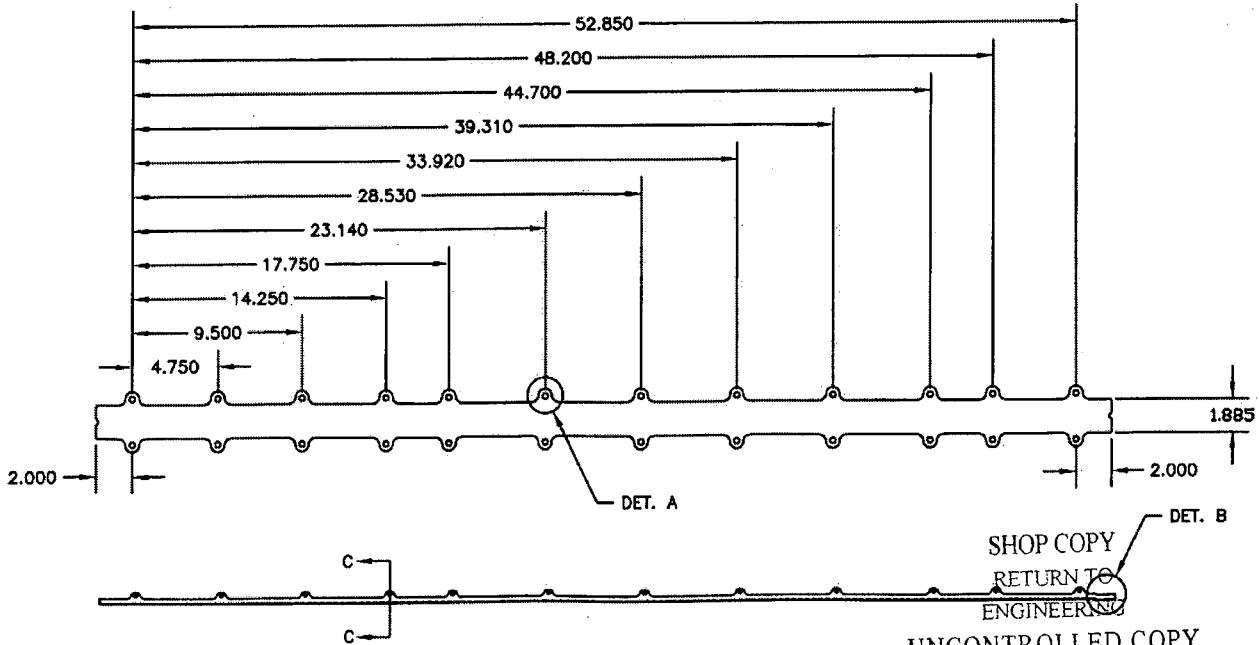
05.09.08

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DATE		TITLE WEARSHOE
05.08.17		SCALE 1:10

D2656-21**RELEASED**
05.09.06D2656-23**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
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WORK ORDER
NO. 27473

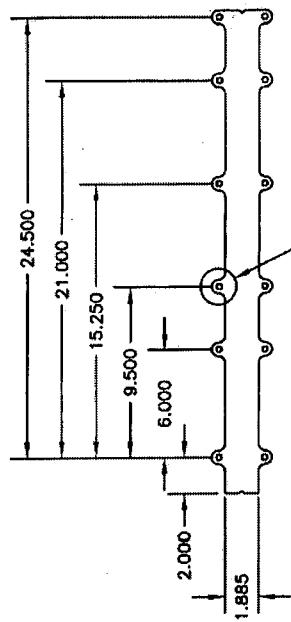
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		D2656
DATE		SHEET 3 OF 4
05.08.17		WEARSHOE
		SCALE
		1:10

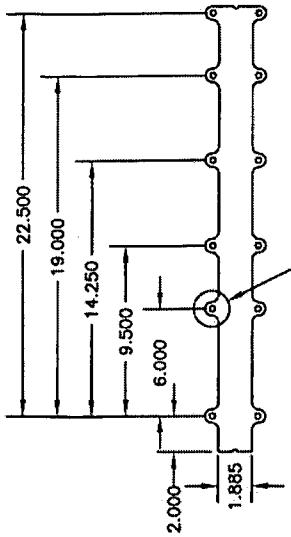
D2656-31



DET. A

DET. A

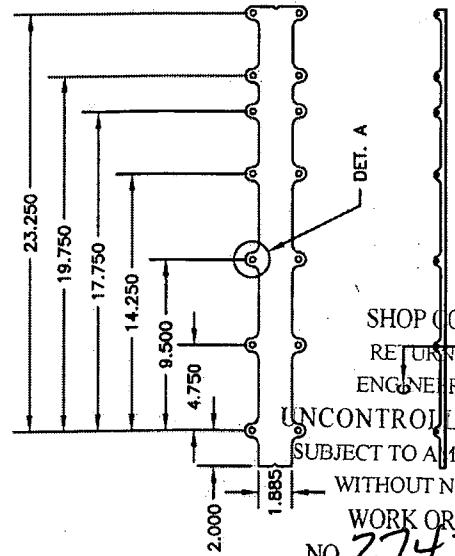
D2656-31



DET. A

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05.07.06

D2656-35



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WORK ORDER
NO. 27473

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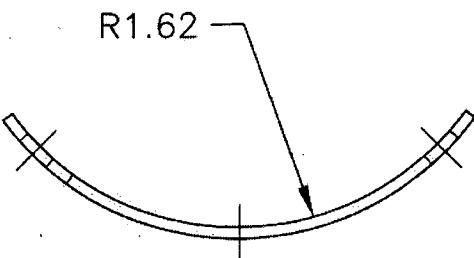
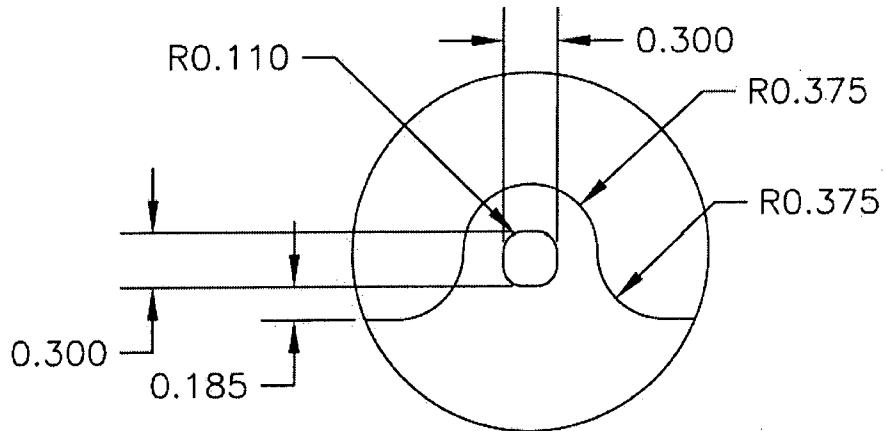
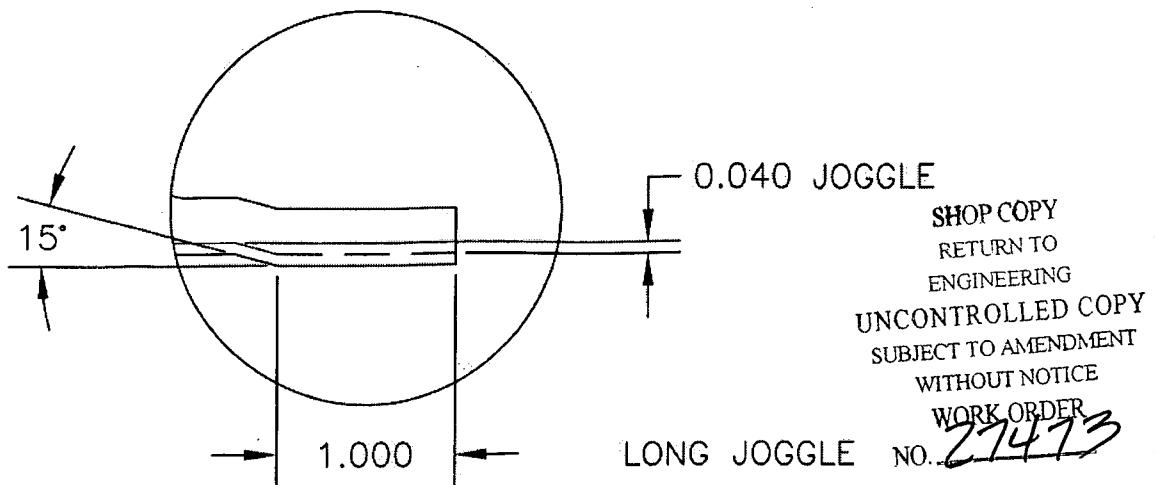
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C**RELEASED**
05.09.06 *AA*DETAIL ADETAIL B

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DART AEROSPACE LTD	Work Order:	27473
Description:	Part Number:	2656-37
Inspection Dwg:	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: <u>M. M</u>	Audited by: <u>S</u>	Prototype Approval: <u>N/A</u>
Date: <u>06.06.13</u>	Date: <u>06.06.21</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	